

Date: Thursday, 3/30/2006 8:31:09 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER
 Job Number : 26416B
 Estimate Number : 10442
 P.O. Number : N/A Part Number : D32623
 This Issue : 3/30/2006 S.O. No. : N/A Drawing Number : D3262 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 23284B Material : N/A
 Due Date : 4/30/2006 Qty: 8 Um: Each
 Written By : See Comment Below
 Checked & Approved By : JA 06.03.30
 Comment : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K
 J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 0.9668 f(s)/Unit Total: 7.7347 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
 (M6061T6B0.500x06.000)
 Identify for D3262-3
 Batch: m100817

J.L. 06/04/29

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 6.000" x 0.500" x 5.400" long Bar
 Machine as per Folio FA457 and Dwg D3262
 Identify for D3262-3
 Deburr

J.L. 06/04/30 (8)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 06/04/30 (8)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JA 06/04/30 8

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 18

J.L. 06.05.16 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 26/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 8:31:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26416B

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/18 (8)

Job Completion



in 06.05.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

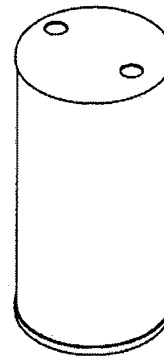
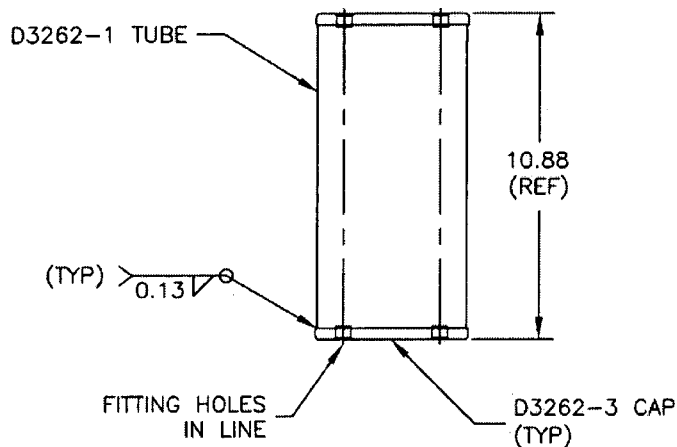
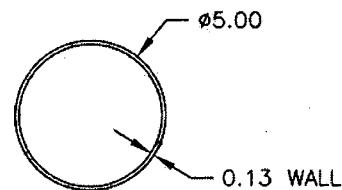
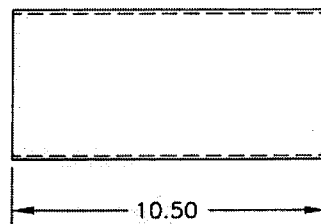
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	.060	✓			
0.45	+/-0.030	.460	✓			
R0.063	+/-0.010	.063	✓			
0.090	+/-0.010	.093	✓			
0.33	+/-0.030	.332	✓			
5.005	+0.010/-0.000	5.005	✓			
0.688	+0.015/-0.000	.690	✓			
3.250	+/-0.005	3.251	✓			
0.875	+/-0.010	.874	✓			
Ø0.516	+0.005/-0.000	.517	✓			
Ø5.190	+/-0.010	5.190	✓			
Ø0.83	+0.015/-0.000	.085	✓			
Ø0.580	+0.005/-0.000	.582	✓			
Ø5.005	+0.010/-0.000					

Measured by: J.L	Audited by: En	Prototype Approval:	N/A
Date: 06/04/29	Date: 06/04/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

RELEASED
05.02.14**D3262-041 CANISTER ASSEMBLY****D3262-1 TUBE****D3262-041:**

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER

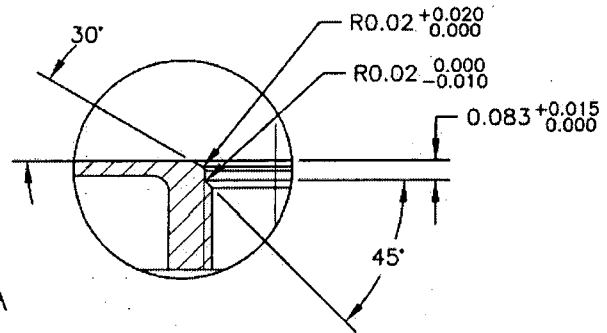
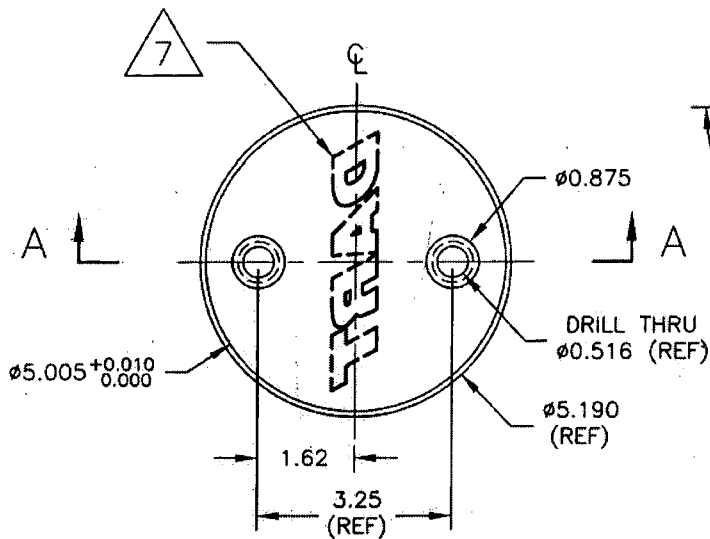
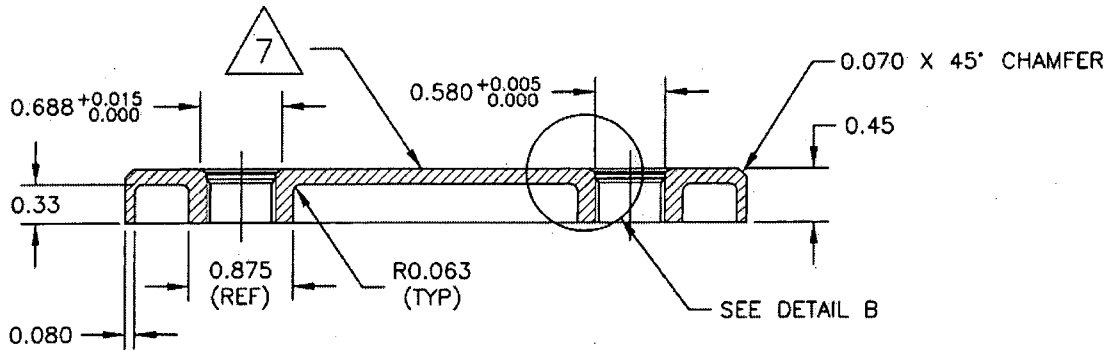
NO. **26416B**

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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:3

**D3262-3 CAP****RELEASED**
05.02.14**D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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